Work Order ID 58075

April 22, 2010 2:24:29 PM



Page 1

Item ID:

D4049-3

Accept

Setup Start

Stop



Revision ID:

Item Name: Mounting Plate, LH

Start Date:

4/22/10

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 4/30/10

QC:

Process Plan:

В

Date:

Date: 10-41-22 Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

Operation Description

Revision Nbr

Set Up/ **Run Hours** Draw Number

Draw Rev.

Plan Accept Qty . Code

Reject Qty

Reject Insp. Number

Stamp

Draw Nbr D4049

Waterjet * !

FLOW CNC Waterjet

304 . 135

1-Cut sheet at 6.00' Dwg Rev: Prog Rev: 13

0.00

0.00

B10-4-26

110

Small Fab

Small Fab

Memo

Form as per dwg D4049

0.00

0.00

| | - | | | | | | | | † | | | |
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| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
| DATE | STEP | PRO | OCEDURE CHA | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | \ : | _ Date: _ | J | | | |
| | | esolution: | | | | | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCR |) | | | | | | |
| DATE | STEP | Description of NC Corrective Action | | | on B | Verific | ation | Approval | Approval | | | |
| DATE | SIEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | Chief Eng | QC Inspector | | | |
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April 22, 2010 2:24:29 PM

Item ID:

D4049-3

Revision ID:

Item Name:

Mounting Plate, LH

Start Date:

4/22/10

Start Qty: 2.00

Req'd Qty: 2.00 Required Date: 4/30/10



Accept.



Setup Start



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Operation

Description

QC: _____ Date: ____ SPC (Y/N):

Tooling:

Set Up/

Date:

Run

Start

Stop



Sequence ID/

Work Center ID

120 QC5= Inspect part completeness to step on W/O

Memo

Quality Control

130

FLOW CNC Wateriet

QC2- Inspect/parts off machine FAI/FAIB

140

Memo

0.00

0.00

Run Hours

Draw Number

Draw Rev.

Date:

Plan Code **Qty**

Reject Accept Qty

Reject Number

Insp. Stamp

0.00

0.00

B 10-4-76

Quality Control

1

2-Debug

1-Gut as per dwg D4049

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| W/O: | | | WC | RK ORDER CHANG | ES | | | | | | | |
| DATE | STEP | PRO | OCEDURE CHAI | NGE | E | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No | • | PAR #: | Fault Cate | gory: | _ NCR: | Yes N | lo DQ | 4 : | Date: _ | | | |
| Reso | | olution: | Disposition | 1: | _ QA: N | /C Clo | sed: | | Date: _ | | | |
| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
| DATE | STEP | Description of NC Corrective Actio | | | on B | | Verific | ation | Approval | Approval | | |
| | 0.2. | Section A | Initial Chief Eng | Action Description Chief Eng | | ign & Date | Secti | | Chief Eng | QC Inspector | | |
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April 22, 2010 2:24:30 PM Line restrict the state of the

Required Date: 4/30/10

Item ID:

D4049-3

Accept



Setup Start



Stop

Item Name: **Start Date:**

Revision ID:

4/22/10

Start Otv: 2.00

Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Mounting Plate, LH

Process Plan:

Date:

Date:

Tooling:

0.00

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

150 100.2



Ouality Control

Memo

Run Hours

Set Up/

Draw Number

Draw Plan Rev. Code

Accept Otv

Reject Otv

Reject Insp. Number Stamp



Packaging

Packaging

Operation Description

OC8- Inspect parts - second check

Identify as per dwg & Stock Location: W/o

58072

0.000.00

PE 10-5-3

170

Memo

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Quality Control

Bf10-5-04

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|-----------|-------|--------------------|----------------------|------------------------------|-----------------------|---------|--------------|---------|-------------------------------|--------------------------|--|--|
| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
| DATE | STEP | PRO | OCEDURE CHAI | NGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| Part No | : | PAR #: | Fault Cate | jory: | NC | R: Yes | No DQ | A: | Date: | | | |
| Resolutio | | solution: | Disposition | 1: | QA: | N/C Cld | sed: | | Date: _ | | | |
| NCR: | | | WORK ORDE | ER NON-CONFORM | MANCE | (NCR | | · · · · | | n (in | | |
| DATE | STEP | Description of NC | | | ection B | 0: 0 | Verific | cation | Approval | Approval | | |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | iption Sign & Date | | Section C | | Chief Eng | QC Inspector | | |
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April 22, 2010 2:24:28 PM

Work Order ID: 58075

D4049-3

Parent Item Name:

Mounting Plate, LH

Comments:

Parent Item:

IPP RevA: new issue DD 10.01.12 verified by:EC

dwg revA DD 10.02.18 verified by:EC

IPP Rev:B as per

Start Date: 4/22/10

Required Date: 4/30/10

Start Oty: 2.00

Required Oty: 2.00

Component Item ID/

Item Name M304S11GA Item ID

Replacement Mfg/ Purch Purchased

Primary Bin Item Location No

Last Location Route Seq ID 100

Unit of sf

Oty on Measure Hand 14.2200

Remaining Qty To Pick 0.4208

Date Issued

Status

304/316 0.125 Sheet

B 10-4.36

Warehouse Location

Main Warehouse

MAT19

112663

Loc Qty

14.22

14.22

Loc Code

114488

114489)

Otv

Issued

| W/O: | | | WORK ORDER CHANGES | | | | | | | | |
|-------------|------|-------------------|----------------------|------------------------------|---------|-------|--------------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PRO | OCEDURE CHA | NGE | В | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | : | | | | 10 | | |
| Part No | : | PAR #: | Fault Cate | gory: | NCR: | Yes N | lo DQ | A: | Date: | | |
| Resolution: | | esolution: | Disposition: (| | | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORM | ANCE (I | VCR) | | | | | |
| DATE | STEP | Description of NC | I a latin I | | tion B | ign & | Verification | | Approval | Approval | |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | Date | | | | Chief Eng | QC Inspector | |
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| DART AEROSPACE LTD | Work Order: 58675 |
|---------------------------------|----------------------|
| Description: Mayoting PLATE LIA | Part Number: 54049-3 |
| Inspection DwgNuN49-3 , Rev: 6 | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

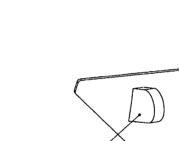
X First Article X Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|-----------|---------------------|------------|--------|-------------------------|----------|
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| Measured by: | IR. | Audited by: | 4 | Prototype Approval: | |
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| Date: | 10-4-76 | Date: | W/24/07 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

QTY -042 ITEM DESCRIPTION D4049-041 D4049-042 MOUNTING LUG ASSY, LH MOUNTING LUG ASSY, RH D4049-1 D4049-2 D4049-3 D4049-4 LUG LUG MOUNTING PLATE, LH MOUNTING PLATE, RH



SHOPCOUT RETURN TO ENGINEERING UNCONTROLLED CO

SUBJECT TO AMENDME

WITHOUT NOTICE WORK_ORD: R

D4049-041 MOUNTING LUG ASSY, LH

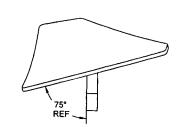
D4049-042 MOUNTING LUG ASSY, RH

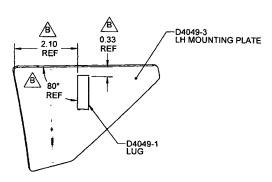
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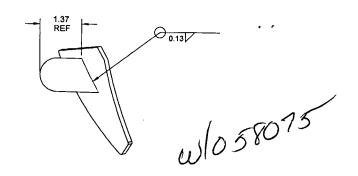
| В | 80° WA | S 83* , 0.33 W | AS 0.55 & 2.10 WAS 2.50 (ZN C6-2) | RF | 10.03.19 | | | | |
|-----------------|--------|----------------|--|---------------|----------|--|--|--|--|
| Α | NEW IS | SUE | | RF | 10.01,29 | | | | |
| REV. | | | DESCRIPTION | BY | DATE | | | | |
| DESIG | | RF RF. | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | | | |
| CHECK MFG. A | | # | DRAWING NO. D4049 | DRAWING NO. R | | | | | |
| APPROVED # | | | MOUNTING LUG ASSY | | | | | | |
| DATE 10.03.19 | | | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COLLINEAR IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION NOT TO BE USED FOR ANY PURPOSE ON COPED OR COMMUNICATED TO ANY OTHER PERSONN WITH THE PERSONNEL FROM THE PERSONNEL PERSONNE | | | | | | |

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| W/O: | | | WORK ORDER CHANGES | | | | | | | | | | |
|--|------|-------------------|-------------------------------------|------------------------------|-------------|----------|-----|-------------------------------|--------------------------|--|--|--|--|
| DATE | STEP | PRO | OCEDURE CHAI | NGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | | | |
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| | | PAR #: | Fault Cate | jory: | NCR: Yes | No DQ | A: | Date: | | | | | |
| | | esolution: | Disposition |): | _ QA: N/C C | losed: | | Date: | | | | | |
| NCR: | | | WORK ORDE | R NON-CONFORMA | NCE (NC | 7) | | | | | | | |
| DATE | STEP | Description of NC | Description of NC Corrective Action | | | Verifica | | | Approval | | | | |
| | O : | Section A | Initial Chief Eng | Action Description Chief Eng | Sign a | | | Chief Eng | QC Inspector | | | | |
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B D4049-041 MOUNTING LUG ASSY, LH

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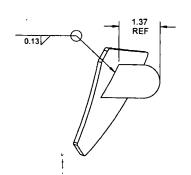
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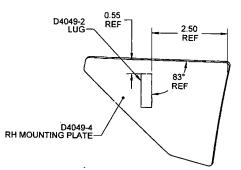
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs
8) WELD PER DART QSI 004 USING WELDING JIG DT9584

| DESIGN | RF | DART AEROSPACE | ITD | | | | |
|------------|------|--|--------------|--|--|--|--|
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | | | | | |
| CHECKED | # | DRAWING NO. | REV. B | | | | |
| MFG. APPR. | 77 | D4049 | SHEET 2 OF 7 | | | | |
| APPROVED | -14 | TITLE | SCALE | | | | |
| DE APPR. | -# | MOUNTING LUG ASSY | NTS | | | | |
| DATE 10.0 | 3.19 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS COCUMENT IS REPORTED FROM THE DEPTH OF COMMENT THAT IS NOT TO BE USED FROM ANY DOES OF COMPANION THE TO ANY OTHER PRISON WITHOUT | | | | | |

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| W/O: | | | W | ORK ORDER CHANG | FS. | 7.4 | | | | |
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| DATE | STEP | PR | OCEDURE CHA | | В | у | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | _ NCR: ` | res N | o DQ | A: | Date: | |
| | | solution: | | | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORM | ANCE (N | ICR) | | | | |
| DATE | STEP | Description of NC | | | | | Verification | | Approval | Approval |
| DAIL | SILF | Section A | Initial Chief Eng | Action Description Chief Eng | | ign & Date | Section C | | Chief Eng | QC Inspector |
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8 D4049-042 MOUNTING LUG ASSY, RH



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В

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-042" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.64 lbs
8) WELD PER DART QSI 004 USING WELDING JIG DT9583

| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | | |
|------------|------|---|--------------|--|--|--|--|
| DRAWN | RF | | | | | | |
| CHECKED | -#1- | DRAWING NO. | REV B | | | | |
| MFG. APPR. | 7 | D4049 | SHEET 3 OF 7 | | | | |
| APPROVED | 4 | TITLE | SCALE | | | | |
| DE APPR. | -74 | MOUNTING LUG ASSY | NTS | | | | |
| DATE 10.0 | 3 10 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONTROL THE LAW IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS | | | | | |

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| W/O: | <u> </u> | | wc | RK ORDER CHANG | FS | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | | | | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | • | PAR #: | Fault Cate | gory: | NCR: Yes | No DQ | A: | Date: | | |
| | R | esolution: | Disposition: QA | | | QA: N/C Closed: Date: | | | | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (NCF | ₹) | | | | |
| DATE | STED | STEP Description of NC Section A | Corrective Action Section B | | | Verificati | | on Approval | Approval | |
| | SILI | | Initial Chief Eng | Action Description Chief Eng | Sign 8 Date | n& Section C | Chief Eng | QC Inspector | | |
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8 D MATCH D4049-3/-4 PROFILE-R0.56 С 109° -REF

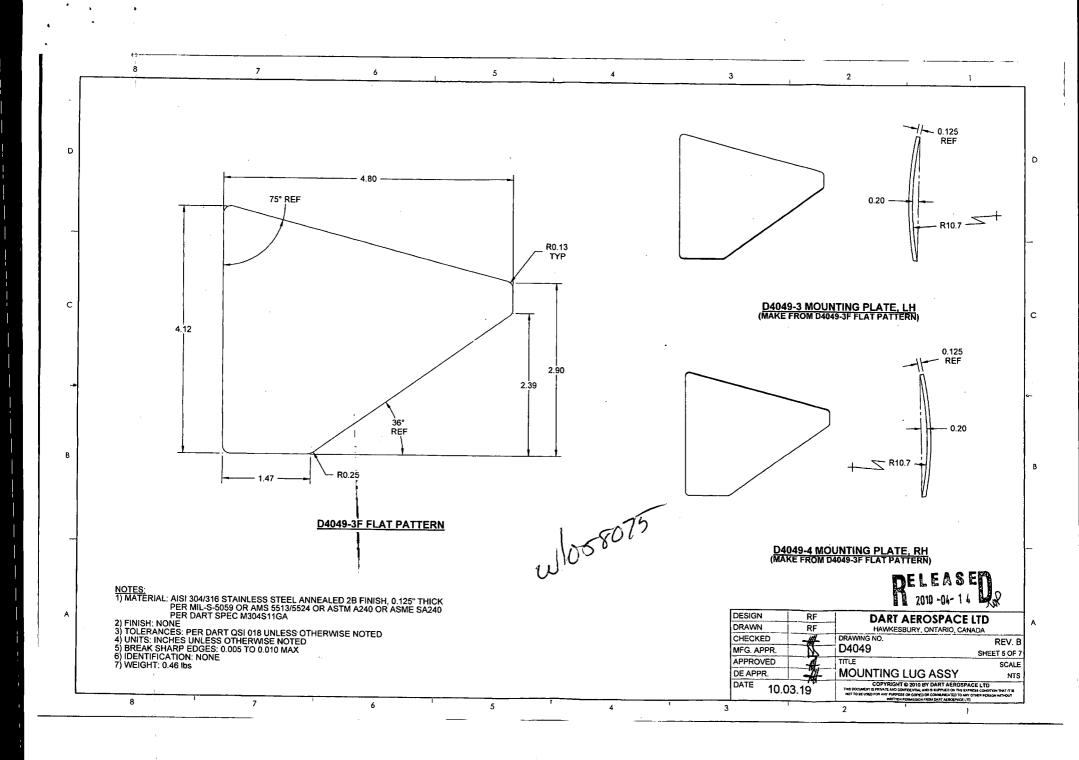
D4049-1 LUG (SHOWN) D4049-2 LUG (OPPOSITE)

NOTES:
1) MATERIAL: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.17 lbs

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| DESIGN | RF | DART AEROSPACE | ITO | |
|------------|------|--|--------------|--|
| DRAWN | RF | HAWKESBURY, ONTARIO, CAN | | |
| CHECKED | _# | DRAWING NO. | REV. B | |
| MFG. APPR. | 172 | D4049 | SHEET 4 OF 7 | |
| APPROVED | #_ | TITLE | SCALE | |
| DE APPR. | | MOUNTING LUG ASSY | NTS | |
| DATE 10.03 | 3.19 | THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE COPPRESS CONDITION THAT IT IS | | |

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| DATE | STEP | PROCEDURE CHANGE | | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No | | PAR #: | Fault Cate | egory: | NCR: | Yes N | lo DQ / | A : | Date: | | |
| Resolution: Disposition: | | | | on: | | | | | | | |
| NCR: | | | WORK ORE | ER NON-CONFORMA | NCE (| NCR) | **** | | | | |
| DATE | STEP Description of NC Section A | Description of NC | Corrective Action Section B | | | | Verific | ation | Approval | Approval | |
| | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Section C | | Chief Eng | QC Inspector | | |
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| Part No | • | PAR #: | Fault Category: NCR: Yes No DQA: | | | | | Date: | | |
| | R | esolution: | Dispositio | QA: N/C Closed: Date: | | | | | | |
| NCR: | | | WORK ORD | ER NON-CONFORMA | NCE (NCR |) | | | | |
| DATE | STEP | Description of NC | Corrective Action Section B | | | Verific | cation | Approval | Approval | |
| | O I E I | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | Chief Eng | QC Inspector | |
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D 0.75 B7-6 R0.13 TYP GRAIN DIRECTION REF 0.36 С 1.00 R0.25 С 2 PL 2.90 1.00 R0.50 Ø0.257 1.60 1.27 R0.13 73° REF ALL AROUND 0.80 VIEW A-A D5-6 1.00 ----**D4049-5 MOUNTING LUG, LH** NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-5" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs DESIGN DART AEROSPACE LTD DRAWN RF, HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B MFG. APPR D4049 SHEET 6 OF 7 APPROVED TITLE SCALE MOUNTING LUG ASSY DE APPR. COPYRIGHT 6 2010 BY DART AEROSPACE LTD
IN BRANKE AND COMPONENT AND BEFFELO ON THE DEFENSE CONTROL
THE PROPERTY OF COMPET OR COMPANICATED TO ANY PURPOSE OR COMPET OR COMPET. NTS DATE 10.03.19 3

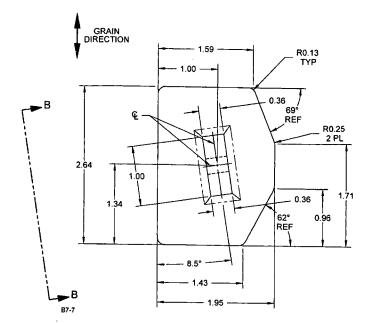
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| W/O: | | | WC | RK ORDER CHANG | GES | | | · | |
| DATE | STEP | PROCEDURE CHANGE | | | | Dat | te Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | jory: | _ NCR: Ye | s No | DQA: | Date: | <u> </u> |
| | | | | Disposition: QA | | | | | |
| NCR: | | , | WORK ORDE | R NON-CONFORM | ANCE (N | CR) | | | · · · · · · · · · · · · · · · · · · · |
| DATE | STEP | Description of NC | Corrective Action Section B | | | Verific | | Approval | Approval |
| | Section A | Initial Chief Eng | Action Description Chief Eng | Sig Da | | Section C | Chief Eng | QC Inspector | |
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0.75 0.50 1.00 REF R0.50 Ø0.257 R0.13 ALL AROUND

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VIEW B-B B5-7



w/058073

D4049-8 MOUNTING LUG, RH

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AMS-QQ-A-225/8 OR AMS-QQ-A-200/8 OR ASTM B211 OR B221
PER DART SPEC M606116B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4049-8" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.10 lbs

| DESIGN | RF | DART AEROSPACE LTD | | | | | |
|------------|---|---------------------------|--------------|--|--|--|--|
| DRAWN | RF. | HAWKESBURY, ONTARIO, CAN | | | | | |
| CHECKED | # | DRAWING NO. | REV. B | | | | |
| MFG. APPR. | 7 | D4049 | SHEET 7 OF 7 | | | | |
| APPROVED | - A | TITLE | SCALE | | | | |
| DE APPR. | # | MOUNTING LUG ASSY | NTS | | | | |
| DATE 10.0 | . COPYRIGHT © 2010 BY DART AEROSP/ this document is private and confidential and is guipping on the gov not to se used for any purpose or copied or communicated to any | RESS CONDITION THAT IT IS | | | | | |

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| DATE | STEP | PR | OCEDURE CH | ANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No: PAR #: | | | Fault Category: NC | | | NCR: Yes No DQA: Da | | | | |
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| NCR: | | | WORK ORE | DER NON-CONFORMA | ANCE (NC | R) | | | | |
| DATE | STEP Description of NC Section A | | Corrective Action Section | | | Verific | fication Approva | | Approval | |
| | | Initial Chief Eng | Action Description Chief Eng | Sign Date | | on C | Chief Eng | QC Inspector | | |
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